

# Work Order ID 53050



Page 1

October 22, 2009 11:28:09 AM

Item ID: D3884-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard LH

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*

Date: *09-10-22*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3884

B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *53050*

Double check by:

1-Machine Step No 1 per Folio FA818 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA818 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA818 and inspect per Dimension Sheets

*SL 09/10/28*

110

QC2- Inspect parts off machine FAI/FAIB

STOP 0.00

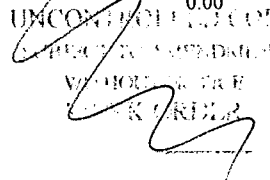


QC

Memo

0.00

Quality Control



*SL 09/10/28*



**Work Order ID 53050**

October 22, 2009 11:28:09 AM



Page 3

Item ID: D3884-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, Inboard LH

Start Date: 21/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

MD 09/11/02

X4



QC

Memo

0.00

Quality Control

160

Identify as per dwg &amp; Stock Location: 429

0.00



Packaging

Memo

0.00

Packaging

9/11/03 40 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/03

MF  
09-11-03

# Picklist Print

October 22, 2009 11:28:17 AM

Page 1

Work Order ID: 53050



Parent Item: D3884-1RevB



Parent Item Name: Saddle, Inboard LH

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-017RevB		Manufactured	No			100	Each	20.0000	4.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20

51835

20

4 SL 09/10/27

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>53050</b>
<b>Description:</b> Saddle, Inboard, LH		<b>Part Number:</b>	<b>D3884-1</b>
<b>Inspection Dwg:</b> D3884 <b>Rev.</b> B		<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.646	.647	.647	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.614	.614	.615	.614		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.004	2.004	2.006	2.004		
J	0.140	0.175		.153	.151	.151	.152		
K	1.265	1.285		1.266	1.267	1.269	1.267		
L	0.115	0.135		.121	.122	.124	.124		
M	0.240	0.260		.245	.246	.249	.249		
N	0.110	0.140		.130	.130	.130	.130		
O	0.240	0.260		.260	.258	.253	.255		
P	2.826	2.886		2.868	2.868	2.868	2.868		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.150	.150	.150	.151		
S	0.720	0.780		.765	.765	.765	.765		
T	1.220	1.280		1.253	1.253	1.253	1.253		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		5.998	5.998	5.998	5.999		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.501	.502	.501	.501		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.315	.315	.315	.315		
AA	0.760	0.765		.760	.760	.760	.760		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.320	.320	.320	.320		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	1.001	1.000	1.000		
AF									
Accept/Reject									

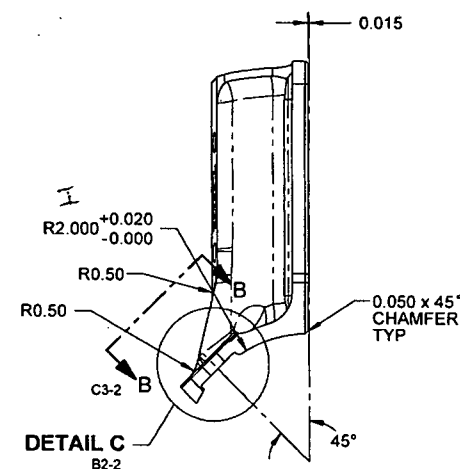
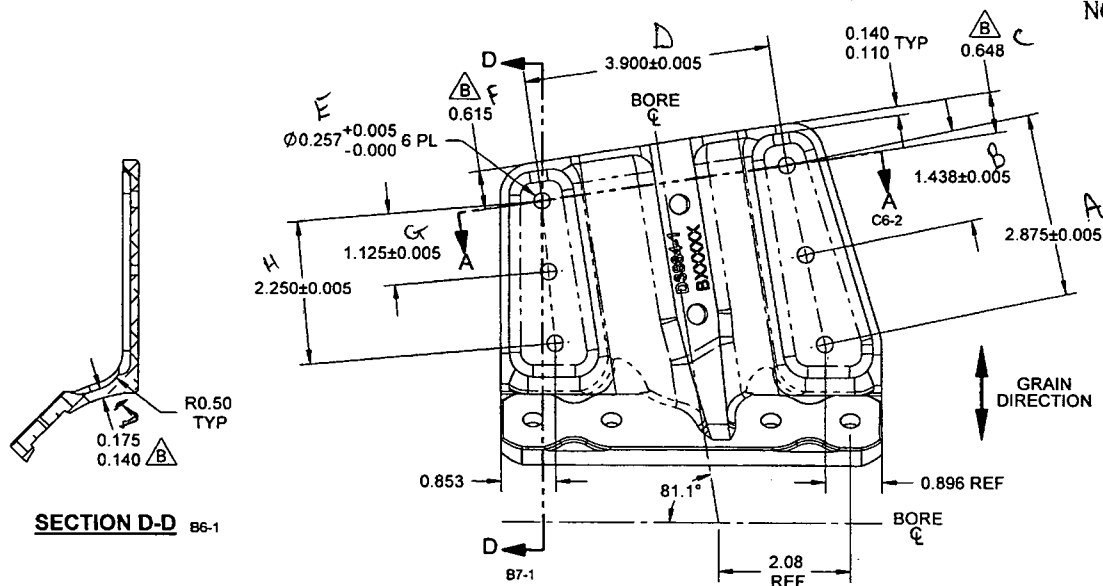
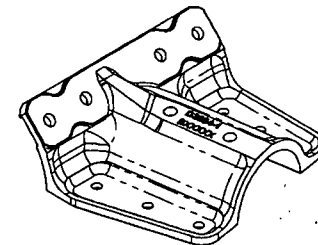
Measured by:	<i>JK</i>
Date:	09/10/28

Audited by:	<i>86</i>
Date:	09/14/28

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	<i>[Signature]</i>

NO.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK CENTER  
NO. 53050  
BP 09-10-27






RELEASED  
07/15/14

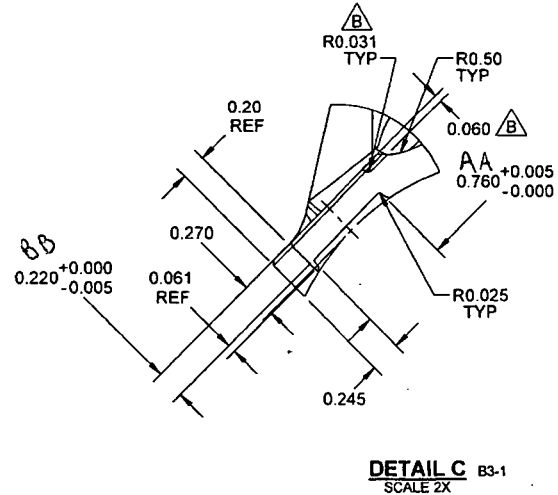
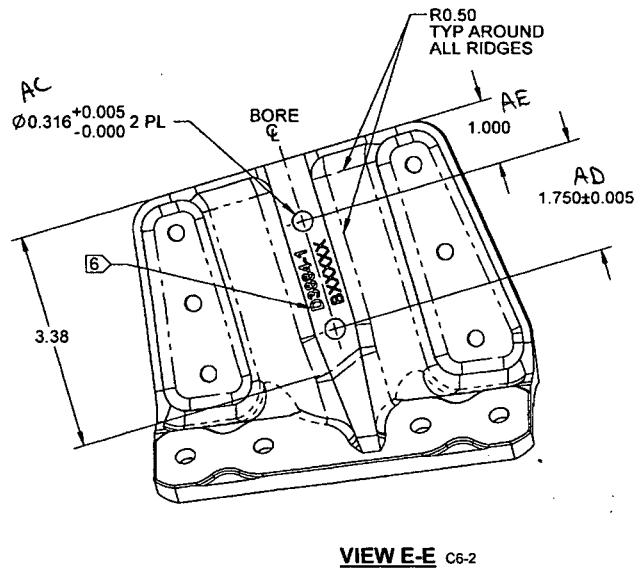
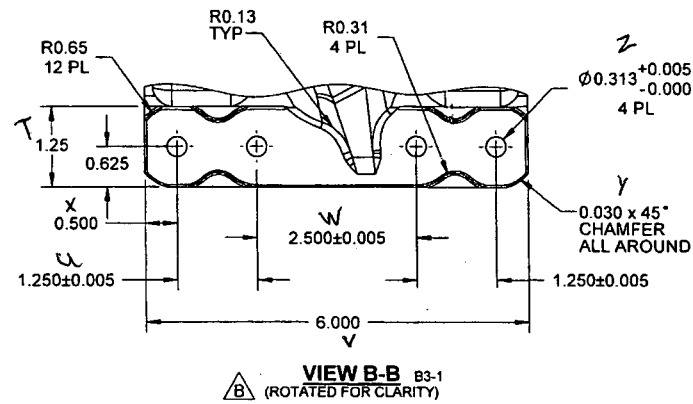
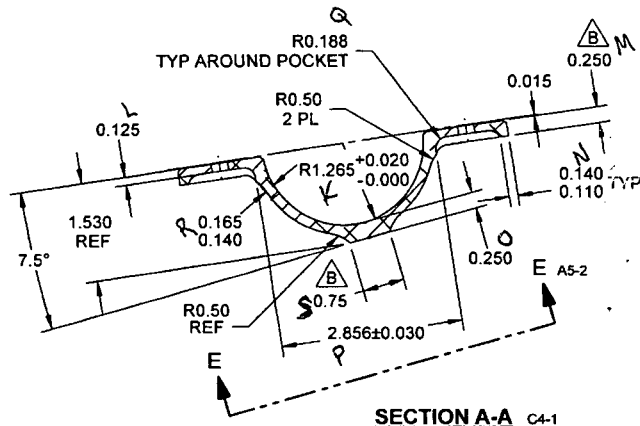
D3884-1 SADDLE, INBOARD LH (SHOWN)  
D3884-2 SADDLE, INBOARD RH (OPPOSITE)

## NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER QQ-A-250/12 OR AMS-QQ-A-250/12 OR AMS-QQ-A-250/12 (REF DART SPEC. D6101-017)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 0.71 lbs

B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE. ZN C4-2; ADD R0.031. ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165. ZN B7-1; ADD 0.615. ZN C8-1; ADD 0.648. ZN C4-1; ADD 0.250. ZN D6-2; ADD 0.080. ZN C2-2; 0.75 WAS 0.65. ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/0 53050



RELEASED  
09/15/15

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.		D3884	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INBOARD SADDLE	NTS
DATE	09.06.30	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	